

# Work Order ID 62427

September 30, 2010 7:59:45 AM



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Item ID: D4172-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/9/30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4172

A

0.00

*M-1 10/04/30*



100



Small Fab

Memo

0.00

Small Fab

- 1- Cut to length as per dwg
- 2- Use DT9657 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*5/10/10/66*



*Pk ->*

*7*

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*BR 10-10-6*



*Review w/ E.D*

*NCR's*

*why not caught during Prelim or validation stage*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4172-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 62427		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
16-10-01	100-2	HOLE SERIES PER DETAL A SHIFTED BY 0.020" ON THE 5.500" DIA (D2-6) RC: JIG NOT PROPERLY PREPARED	10-10-01	THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT ALL THE HOLES ARE STILL WITHIN 0.010" FROM EACH OTHER,	M-1 10/10/05	S 10/10/05	10-10-01	10/10/01
		AT THE END STOPPER. FLASH OF WELDING PREVENTING FROM LOCATING PART CORRECTLY.		PER DRAWING, FURTHERMORE, THERE IS ENOUGH CLEARANCE AND PLAT PROVIDED BY THE NOTPLATE TO COMPENSATE.				
10/10/01	# 100	Found at inspection that Dia .563 was measuring from one end <del>500</del> .553 - and the other .583 RC new jig is off.	10-10-04	SCRAP PARTS. CORRECT OR MAKE NEW DRILLING JIG, PRIOR TO MAKING REPLACEMENT FOR SCRAP PARTS SCRAPPED	10-10-04 M-1 10/10/05	S 10/10/05	10-10-04	10/10/01

NOTE: Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00

10/10/06

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location 241A

0.00

Packaging

Memo

0.00

Packaging

10/10/06

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/07

MF  
10-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62427

Parent Item: D4172-3

Parent Item Name: Support Angle



Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6A1.000W.125

Purchased

No

100

f

90.9100

6.25

6.578947



6061T6 ANGLE 1.00 x 1.00 x .125W



M-L 10/04/30

Location

Loc Qty

Loc Code

MAT

90.91

115688

10.91

115776 ✓

80

6.578947

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

